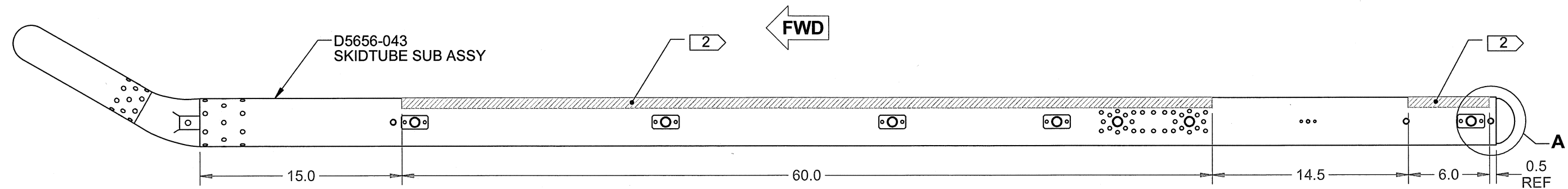
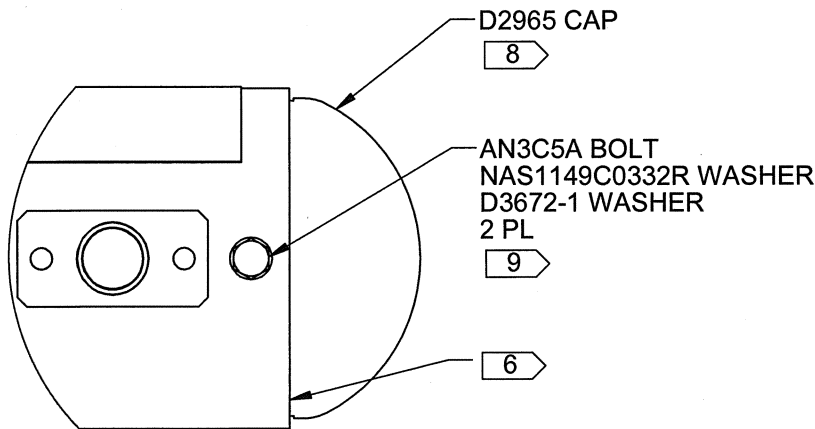


QTY -041	P/N	DESCRIPTION
X	D5656-041	SKIDTUBE
1	D2965	CAP
2	D3672-1	PHENOLIC WASHER
1	D5656-043	SKIDTUBE SUB ASSY
2	AN3C5A	BOLT
2	NAS1149C0332R	WASHER



D5656-041 SKIDTUBE



DETAIL A  
SCALE 4X

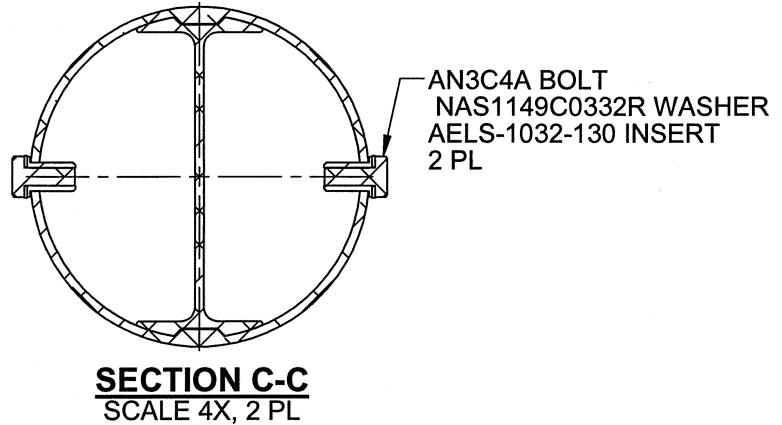
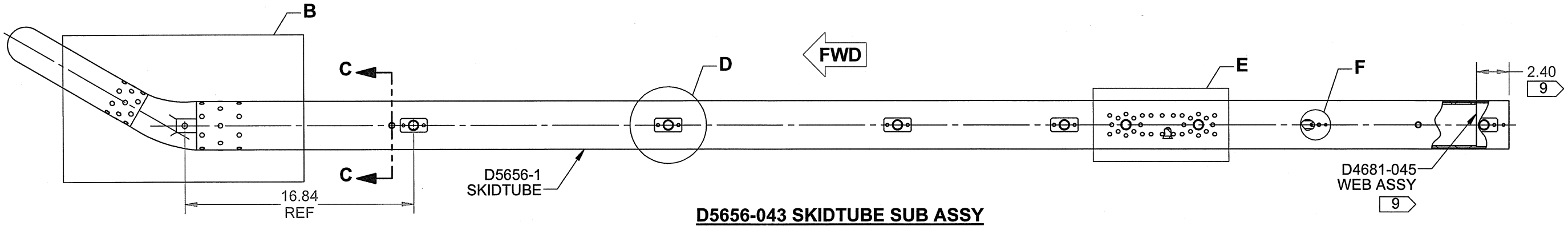
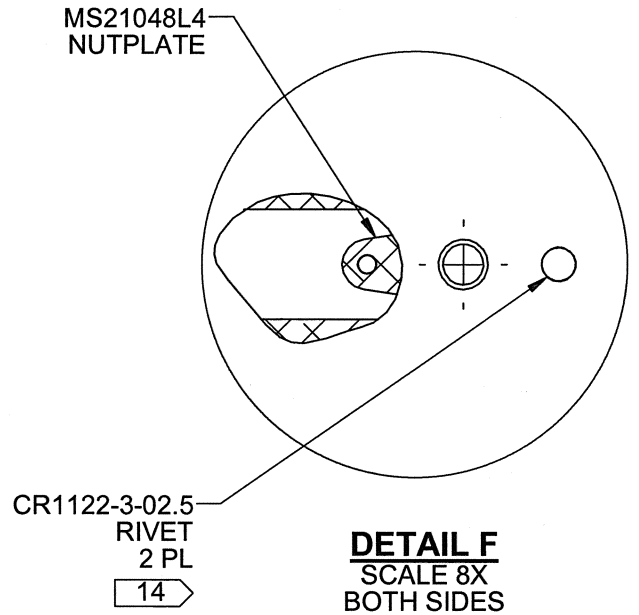
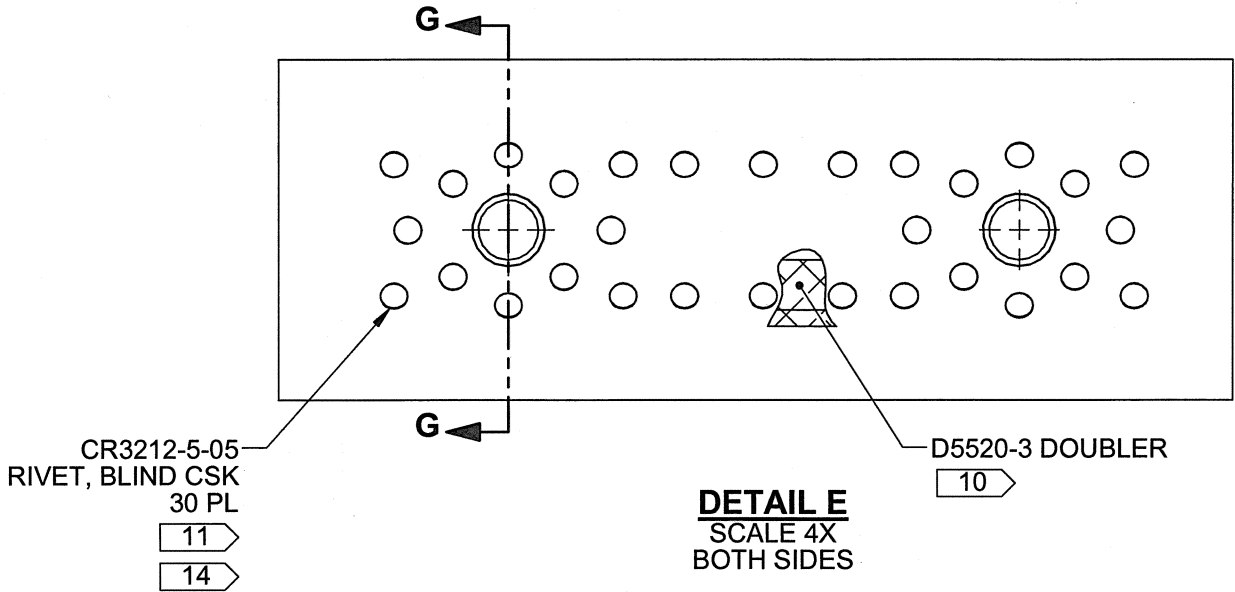
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: SCRIBE DART P/N "D5656-041" AND S/N PER DART QSI 044 6.4 ON INNER RADIUS OF AFT END OF TUBE BEFORE INSTALLING CAP
  - 7) WEIGHT: 22.60 lbs
  - 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT
  - 9) WET INSTALL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT

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2019 SEP 10 NP  
ECN19-890

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A	NEW ISSUE	ZF	18.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5656	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
DATE	18.11.29	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

QTY -043	P/N	DESCRIPTION
X	D5656-043	SKIDTUBE SUB ASSY
1	D4681-045	WEB ASSY
5	D4686-1	SPACER
10	D4753-1	DOUBLER
2	D5304-1	CROSSBOLT SPACER
2	D5520-3	DOUBLER
1	D5656-1	SKIDTUBE
1	D5658-1	FWD TRANSITION
1	D5658-3	FWD EXTENSION
4	AELS-1032-130	INSERT
4	AN3C4A	BOLT
4	CR1122-3-02.5	RIVET
60	CR3212-5-05	CSK RIVET, CHERRY MAX
24	CR7620S0504	BLIND RIVET
24	CR7620S0505	BLIND RIVET
20	MS20601AD4W3	RIVET, BLIND, CSK
2	MS21048L4	NUTPLATE
4	NAS1149C0332R	WASHER

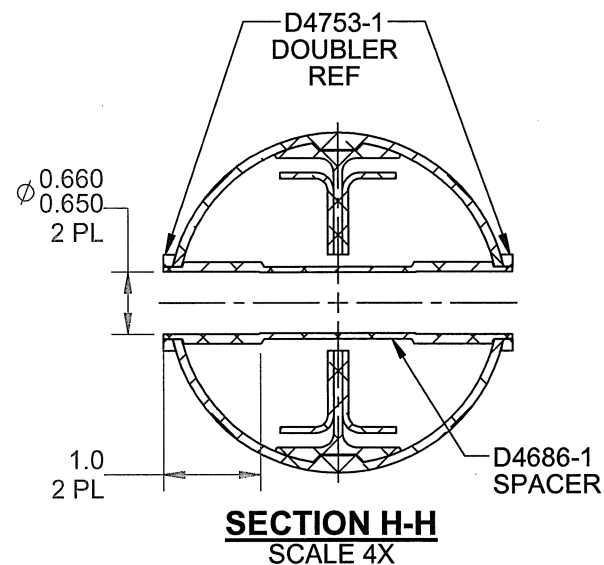
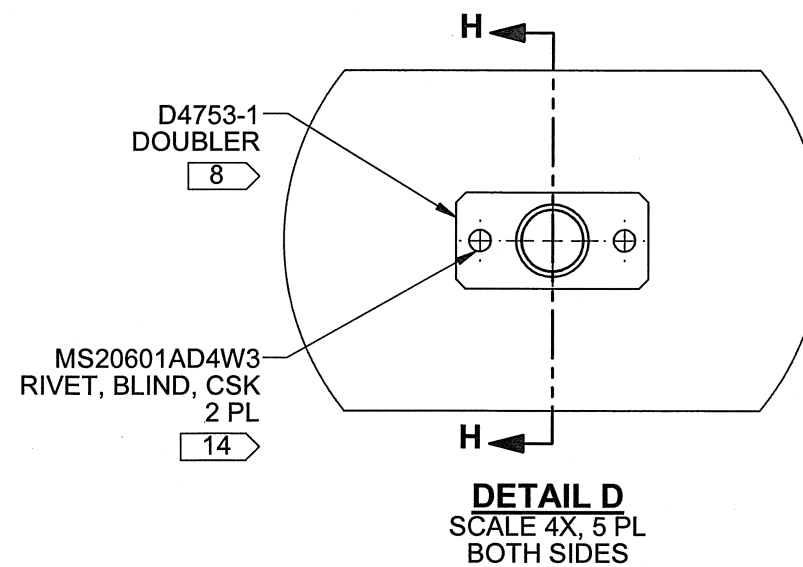
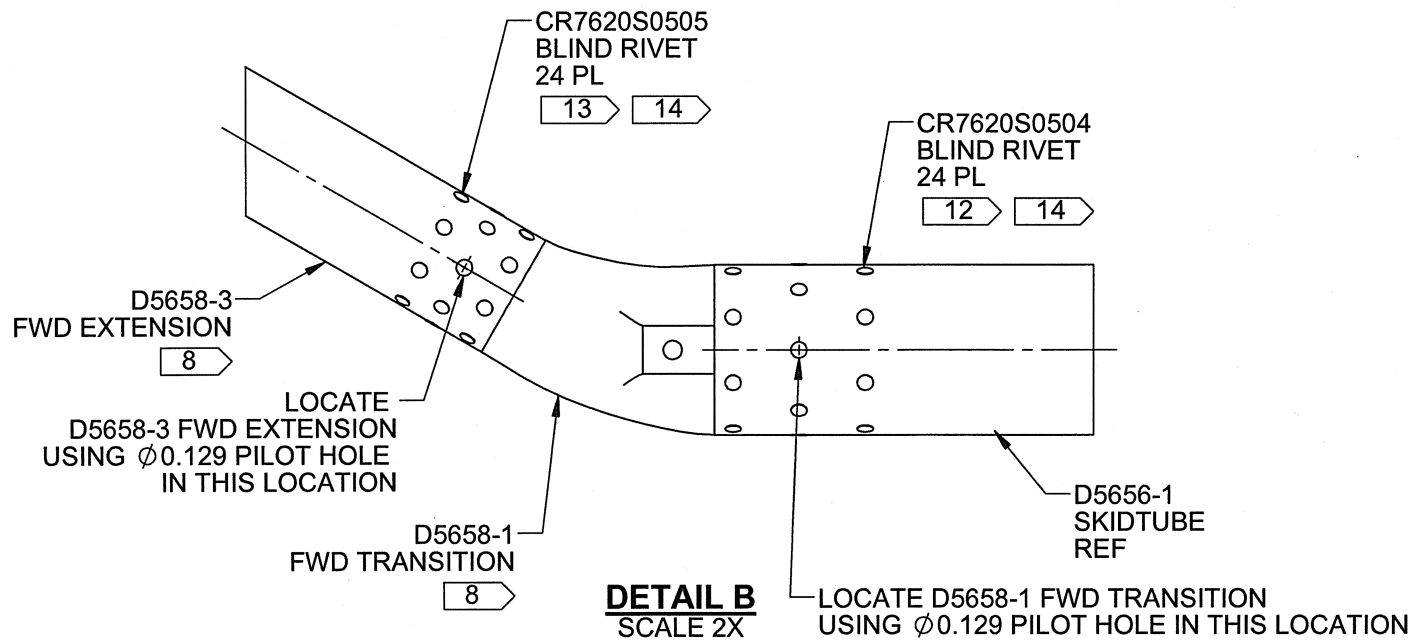


- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 21.66 lbs
  - 8) SEAL FAYING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT
  - 9) INSTALL WEB ASSY INTO SKIDTUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015, LOCATE AS SHOWN
  - 10) LOCATE THE D5520-3 DOUBLER USING THE  $\phi 0.188$  PILOT HOLES IN THE SKIDTUBE AND DOUBLER
  - 11) DRILL QTY (30)  $\phi 0.160 / 0.164$  (#20 DRILL) HOLES THRU SKIDTUBE AND D5520-3 DOUBLER USING TOOL DT 10481  
COUNTERSINK THE SKIDTUBE HOLES TO  $\phi 0.283 / 0.289 \times 100^\circ$   
DEBURR HOLES AND TOUCH UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541  
INSTALL DOUBLER USING CR2312-5-05 RIVETS
  - 12) TRANSFER DRILL QTY (24)  $\phi 0.129$  (#30 DRILL) HOLES FROM SKIDTUBE TO D5658-1 FWD TRANSITION  
OPEN HOLES THRU SKIDTUBE AND D5658-1 FWD TRANSITION TO  $\phi 0.164 / 0.167$   
COUNTERSINK THE SKIDTUBE HOLES TO  $\phi 0.327 / 0.335 \times 100^\circ$   
DEBURR HOLES AND TOUCH UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541  
INSTALL D5658-1 FWD TRANSITION USING CR7620S0504 RIVETS
  - 13) TRANSFER DRILL QTY (24)  $\phi 0.129$  (#30 DRILL) HOLES FROM D5658-3 FWD EXTENSION TO D5658-1 FWD TRANSITION  
OPEN HOLES THRU D5658-3 FWD EXTENSION AND D5658-1 FWD TRANSITION TO  $\phi 0.164 / 0.167$   
COUNTERSINK THE D5658-3 FWD EXTENSION HOLES TO  $\phi 0.327 / 0.335 \times 100^\circ$   
DEBURR HOLES AND TOUCH UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541  
INSTALL D5658-3 FWD EXTENSION USING CR7620S0505 RIVETS
  - 14) WET INSTALL RIVETS USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT

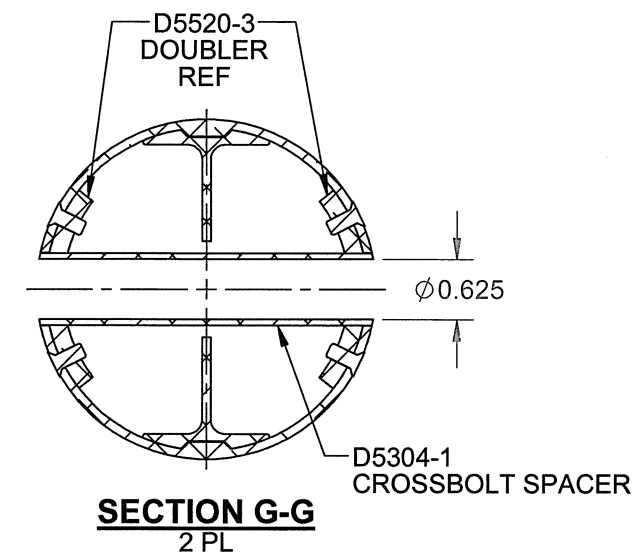
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2019 SEP 10 NP

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DESIGN	ZF	DART AEROSPACE USA, INC.	
DRAWN	MW	HILLSBORO, OR	
CHECKED	ZF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5656	SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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- INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS AS FOLLOWS:
1. REAM  $\phi 0.758$  THRU DOUBLERS AND SKIDTUBE.
  2. INSERT D4686-1 SPACER
  3. SWAGE TO  $\phi 0.660 / 0.650 \times 1.0$  DP EACH SIDE PER DART QSI 002
  4. TRIM/GRIND SPACER FLUSH WITH DOUBLER PER QSI 002



- INSTALL D5304-1 CROSSBOLT SPACER AFTER INSTALLING D5520-3 DOUBLERS AS FOLLOWS:
1. OPEN PILOT HOLES THRU SKIDTUBE AND DOUBLERS TO  $\phi 0.758$
  2. INSERT D5304-1 CROSSBOLT SPACER
  3. SWAGE TO  $\phi 0.570 / 0.565 \times 1.0$  DP EACH SIDE PER DART QSI 002
  4. OPEN HOLE THRU SPACER TO  $\phi 0.625$

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DESIGN	ZF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	MW	HILLSBORO, OR	
CHECKED	ZF	DRAWING NO. <b>D5656</b>	REV. A
MFG. APPR.	DD	SHEET 3 OF 4	
APPROVED	NO	TITLE <b>SKIDTUBE</b>	SCALE
DE APPR.	DS	NTS	
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